Amendments to the Claims

This listing of the Claims will replace all prior versions and listings of the claims in this patent application.

Listing of the Claims

1. (currently amended) A method of fabricating a composite tubular door frame comprising the steps of:

   (a) laying-up a plurality of layers of composite fabric on a mould having an upper mould component and a lower mould component, said mould having a plurality of corners, and each layer of said composite fabric being compacted by applying vacuum;

   (b) placing a plurality of nylon tubes over said composite fabric at said upper mould component with ends of said nylon tubes being extended out at each of ~~the~~ said corners of said mould and placing a main bag over the top and enveloping said upper mould component and sealing said nylon tubes;

   (c) proceeding the mould to a curing step wherein curing pressure is applied in the enclosure enveloped by said main bag and sealing said nylon tubes; and

   (d) thereafter removing said main bag from said mould and pulling out said nylon tubes from said mould and removing said mould to obtain a tubular door frame.

2. (previously presented) The method of claim 1, wherein said composite fabric is selected from the group consisting of glass, carbon, boron, and aramid and wherein said composite fabric is pre-impregnated with epoxy resin.

3. (previously presented) The method of claim 1 , wherein said curing pressure is 4 to 7 bars with a 0.3 to 0.7 bar vacuum.

4. (previously presented) The method of claim 3, wherein said mould is heated in an autoclave to 80 degrees C and held for 30 to 90 minutes.

5. (previously presented) The method of claim 4, wherein said curing pressure applied to said autoclave during said 80 degrees C is 4 bars.

6. (previously presented) The method of claim 5, wherein after said holding for 30 to 90 minutes, the temperature of said autoclave is gradually increased to 120 or 180 degrees C.

7. (previously presented) The method of claim 6, wherein said temperature of 120 or 180 degrees C is held for 2 hours before cooling to room temperature.

8. (currently amended) A method of fabricating a composite tubular frame comprising the steps of

(a) laying-up a plurality of layers of composite fabric on a mould having an upper mould component and a lower mould component, said mould having a plurality of

corners, and each layer of said composite fabric being compacted by applying vacuum;

(b) placing a plurality of nylon tubes over said composite fabric at said upper mould component with ends of said nylon tubes being extended out at each of ~~the~~ said corners of said mould and placing a main bag over the top and enveloping said upper mould component and sealing said nylon tubes;

(c) proceeding said mould to a curing step wherein curing pressure is applied in the enclosure enveloped by said main bag and sealing said nylon tubes;

(d) thereafter removing said main bag from said mould and pulling said nylon tubes from said mould and removing said mould to obtain a tubular door frame; and

(e) trimming off of excessive said composite fabrics from said tubular door frame .

9. (previously presented) The method of claim 8, wherein said curing pressure is 4 to 7 bars with a 0.3 to 0.7 bar vacuum.

10. (previously presented) The method of claim 8, wherein the vacuum applied in said curing step is 0.5 bar.

11. (previously presented) The method of claim 8, wherein said nylon tubes pressurize the inner wall of said composite fabric during curing.

12. (previously presented) The method of claim 8, wherein said composite fabric is selected from the group consisting of carbon, glass, boron, and aramid and wherein said composite fabric is pre-impregnated with epoxy resin.

13. (previously presented) The method of claim 8, wherein said mould is heated in an autoclave to 80 degrees C and held for 30 to 90 minutes.

14. (previously presented) The method of claim 9, wherein said curing pressure applied to said autoclave during said 80 degrees C is 4 bars.

15. (previously presented) The method of claim 10, wherein after said holding for 30 to 90 minutes, the temperature of said autoclave is gradually increased to 120 or 180 degrees C.

16. (previously presented) The method of claim 11, wherein said temperature of 120 or 180 degrees C is held for 2 hours before cooling to room temperature.

17. (previously presented) The method of claim 4, wherein the pressure applied to said autoclave is preferably 4 bars.

18. (previously presented) The method of claim 1, wherein the vacuum applied in said curing step is 0.5 bar.

19. (previously presented) The method of claim 1, wherein said nylon tubes pressurize the inner wall of said composite fabric during curing.